

Date: Thursday, 12/1/2005 12:56:17 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR ASSEMBLY
<b>Job Number</b> : 25075	
<b>Estimate Number</b> : 10253	
<b>P.O. Number</b> : <u>N/A</u>	<b>Part Number</b> : D2183
<b>This Issue</b> : 12/1/2005 <b>S.O. No.</b> : <u>N/A</u>	<b>Drawing Number</b> : D2183 REV B1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <u>N/A</u> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 24747	<b>Material</b> : <u>N/A</u>
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 12/8/2005 <b>Qty:</b> 5 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>SEE COMMENT BELOW</u>	
<b>Comment</b> : Est: F 02.04.27 Added D3161-1 Hinge (MPP 2241) NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2116	Door Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
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1	D2116	Door Panel	<u>1 016178 4 012426</u>
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SB 05/12/11

5

2.0	D2117	Door Panel
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
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1	D2117	Door Panel	<u>1 023390</u>
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SB 05/12/11

5

3.0	D31611	Hinge 13.5"
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge

Pick:

Qty	Part Number	Description	Batch
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2	D3161-1	Hinge	<u>1 118708</u>
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SB 05/12/11

P/O 5

4.0	MS20470AD44	Rivet, Universal Head
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**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
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24	MS20470AD4-4	Rivet	<u>1 118729</u>
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SB 05/12/11

5

made by Rand Took, MS 20257-3-7200 H 17808

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 25075

Part Number: D2183

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill holes in D3161-1 13.5" hinges using DT 8239

Rivet assembly per Dwg D2183

SB 05/12/11

5

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2-05-12-05 5

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat black sandtex (4.3.5.7) per QSI 4.3

Note: Hinges are to be broken back and forth immediately after powder coating to ensure free mobility of hinge.

FC 06/01/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11/11 06/01/23

9.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Rivet

Pick:

Qty Part Number

Description

Batch

1 MS20470AD4-6

Rivet

M17566

DL 06/01/24

10.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

1 AN960JD6

Washer

M6085

DL 06/01/24

11.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Decal - No Step

Pick:



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Job Number: 25075

Part Number: D2183

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part number	Description	Batch
1	D2137	'NO STEP' Decal	B23661

DL 06/01/24

12.0

D24620270

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Seal

Pick:

Qty	Part number	Description	Batch
1	D2462-0270	Seal	B22749

DL 06/01/24

13.0

D28541050

Velcro Strip - Looped



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Velcro Strip - Looped

Pick:

Qty	Part number	Description	Batch
1	D2854-1-050	Velcro Strip	B10189

DL 06/01/24

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2183

Note: Ensure Decal is firmly attached to panel

DL 06/01/24

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06-01-24 5

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 215

DL 4/1/26

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/30

DL 06/01/30

Job Completion



